

Date: Tuesday, 16/09/2008 1:21:57 PM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : REPLACEMENT WINDOW ASSEMBLY

Job Number : 42024-1

Estimate Number : 11174

P.O. Number :

This Issue : 16/09/2008 S.O. No. :

Prsht Rev. : NC

First Issue : // Type : SMALL /MED FAB

Previous Run : 39870

Part Number : D3290041

Drawing Number : D3290 REV C

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 30/09/2008

Qty: 4 Um: E2

Written By :

Checked &amp; Approved By :

Comment :

Est. B 05.05.25 Added Step 11 KJ/JLM

Est. C 06.05.09 Ecn 798 EC

Est Rev:D Now on Waterjet 06-06-16 JLM

Est rev E rev C dwg 07.09.28 EC verified by: DD

## Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S040

6061-T6 .040 Sheet

Comment: Qty.: 3.9375 sf(s)/Unit Total : 39.3750 sf(s)

M6061T6S040

Batch: 107461 B 8-9-17

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3290 ( use prog. for D3290-1)

Dwg Rev: C

Prog Rev: C

B 8-9-17

2-Deburr if necessary

B 8-9-17

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

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6.0

POWDER COATING

POWDER COATING

Description :

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:30 AM

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2126

Seal

Comment: Qty.: 6.5000 f(s)/Unit Total: 65.0000 f(s)  
Locking Seal

Pick:

Qty	Part Number	Description	Batch
1	D2126-0780	Locking Seal	

9.0

D32903

Window

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)  
Window

Pick:

Qty	Part Number	Description	Batch
1	D3290-3	Window	

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

11.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

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Job Number:

Part Number: D3290041

Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 813

13.0

QC21

8/9/29  
FINAL INSPECTION/W/O RELEASE

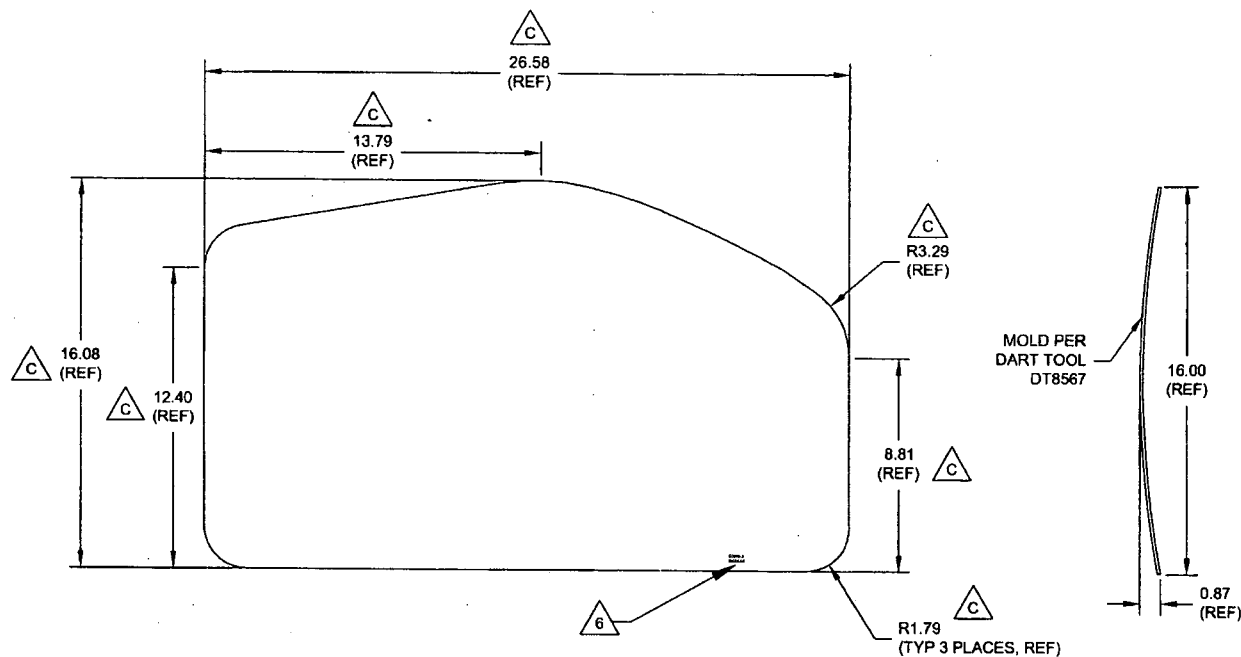
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

08/09/30  
MF 08-09-30













**D3290-3 WINDOW**

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) REMOVE SHARP EDGES
  - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
  - 7) WEIGHT: 1.87 +/- 0.42 LBS
  - 8) MOLD PER DART TOOL DT8567

**RELEASED**  
07.07.22

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:	
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